

Date: Monday, 9/10/2007 1:32:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER KIT	
Job Number	: 34519		Part Number	: D25251	
Estimate Number	: 11799		Drawing Number	: D2525 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/10/2007	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/2/2007	
Previous Run	: 27583		Qty:	50	Um: Each
Written By	:		Checked & Approved By	:	
Comment	: Est. B 99.11.10 Re-format added Acid etch step EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750"
Comment: Qty.: 0.0656 f(s)/Unit Total : 1.3125 f(s) 6061-T6 Round Bar .750" (M6061T6R0750) Batch: M103857 <i>DSR 07/10/27</i>		
2.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE Turn as per Dwg D2525 <i>DSR 07/10/27</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DSR 07/10/27</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>DSR 07/10/27</i>		
5.0	HAND FINISHING	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005.4.1 <i>98 04-00-29</i>		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>07/11/30 JC</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

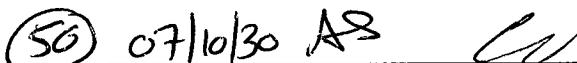
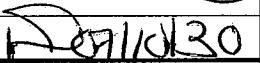
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/130
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34519		Part Number: D25251
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST35 		
8.0	QC21 	FINAL INSPECTION/W/O RELEASE  
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion  		

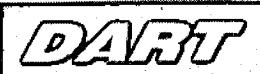
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

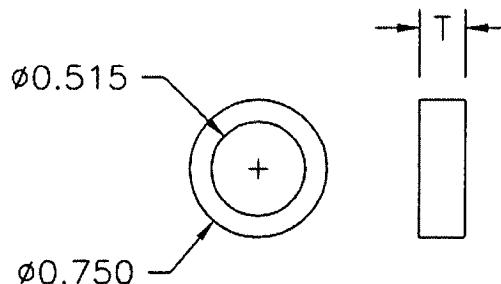
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED MF	DRAWING NO. D2525
DATE 99.09.30		REV. B SHEET 1 OF 1 SCALE 1:1
A	95.12.22	NEW ISSUE
B	99.09.30	REVISED MATERIAL

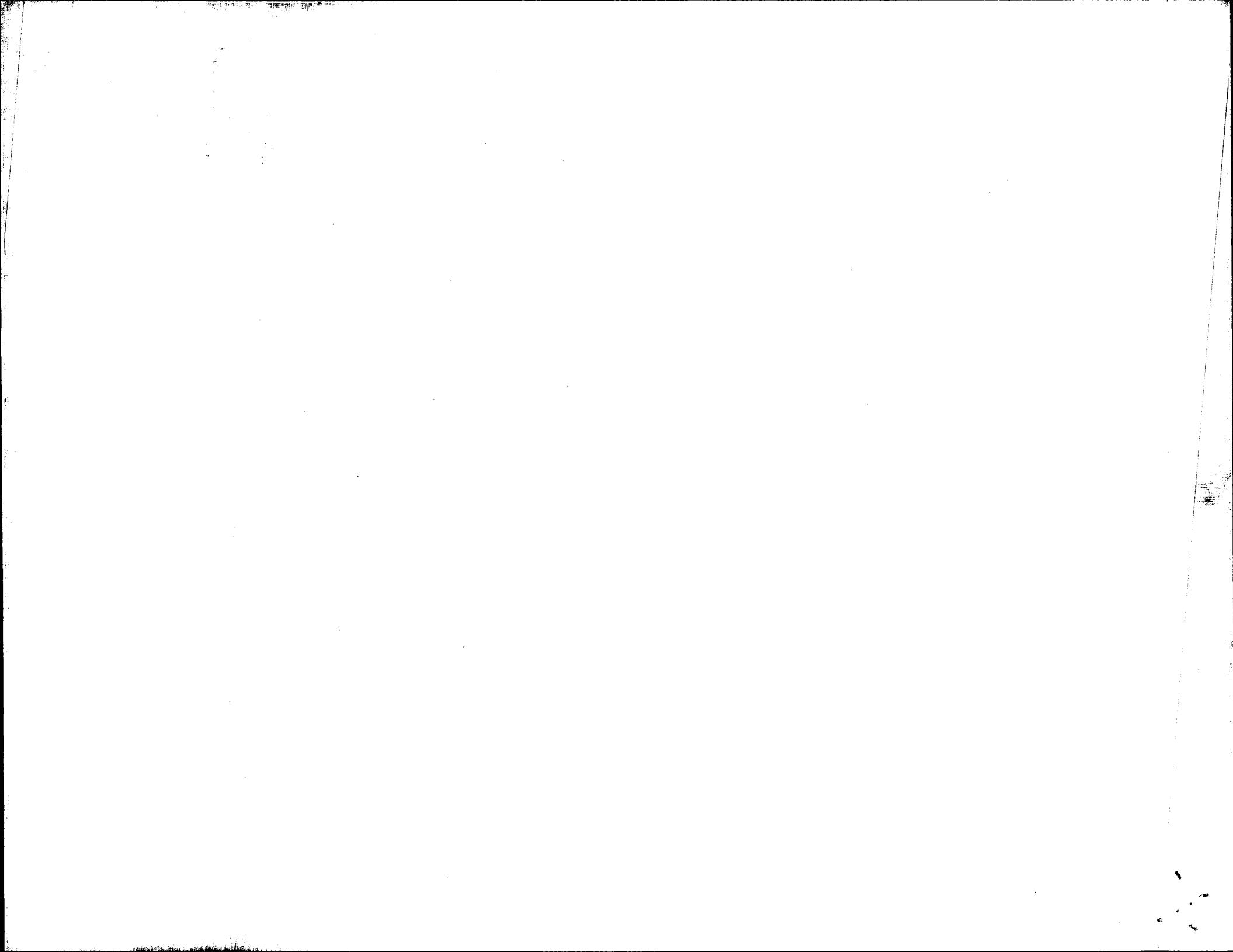
RELEASED
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
 OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO 34519



DART AEROSPACE LTD	Work Order:	34519
Description: Spacer Kit	Part Number:	D25251
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>DJP</u>	Audited by: <u>SC</u>	Prototype Approval:
Date: <u>07/10/27</u>	Date: <u>07.10.27</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	